| | er ID 97346 - 15, 2013 2:22:55 PM | | *973 | 46* | | <u> </u> | | (M) | 737 | Page 1 |
|--|---|------------------|----------------------|------------------------|-------------|--------------|---------------|-------------------|------------------|----------------|
| Revision ID: | D3876-1 Protector - RH Fwd Wall | | Accept | *N900 | <u>1040</u> | 100 |)* s | Setup Start | I VI. | |
| | 2/16/2013 Start Qty: 6.00 | *6* *6* | | Cust Item Customer: | | | | 313 p | ^N; | S2* |
| | Process Plan: MC | Date: (3-2-1°) | Tooling: SPC (Y/N): | | Pate: | - | F | Run Start Stop | 1/1 | R1* R2* |
| Sequence ID/ Work Center ID | | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr | Revision Nbr | | . — | | | | | | | ********* |
| D3876 | A | | *- *. <u></u> | | | | | | | |
| *100 *100* Waterjet FLOW CNC Waterjet | FLOW WATER JET Memo t 1-Cut as pe Dwg Rev: | r Dwg D3876 | 0.00 | | | | 6 | Ó | | Jn 13-2-2 |
| | Prog Rev:_ 2- Deburr it | necessary | | | | | | | | |
| 110 | QC2- Inspect parts off n | nachine FAI/FAIB | 0.00 | | | | | | • | |
| *110* QC Quality Control | Memo | | 0.00 | | | | 6 | | , | Jm 13-2-2 |
| ¹²⁰ *12∩* | QC8- Inspect parts - sec | ond check | 0.00 SW | 1 | | | 6 | | | · |
| QC | Memo | | 0.00 1322 | 1 | | | ~ ~~ | | | |

Quality Control

WORK ORDER NON-CONFORMANCE / UPDATE Yes / No NCR: QA Closed: Date: AGAINST DEPARTMENT/PROCESS DISPOSITION Work Order: Skid-tube Crosstube Water Jet Engineering Rework Small Fab Prod. Eng. Coor. Quality Part No. Scrap Machining Finishing Rec/Store/Packaging Other Thermoforming Use-as-is NCR No. Work Order Update Large Fab Supplier Composite Description of work order update Initial Action Sign & Root Verification QC Inspector Chief Eng Description Date Date Step Qty or Non-conformance Cause Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Grain Ovalized Bend Bending BOM/Route Over/Under tolerance Temperature/Cure Hardware Centre Not Concentric to O/S Part Incorrect Weld Cracks Broken/Damaged Inspection Incomplete

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

DQA:

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Date:

Wrong Stock Pulled

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Work Order ID 97346 *97346* Page 2 Friday, February 15, 2013 2:22:55 PM Item ID: D3876-1 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Protector - RH Fwd Wall **Start Date:** 2/16/2013 Start Qty: 6.00 **Cust Item ID:** Required Date: 2/20/2013 Req'd Qty: 6.00 **Customer:** Reference: Run **Approvals: Process Plan:** Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # **Tool ID** Reject Plan Accept Reject Insp. Work Center ID Description Qty Qty **Run Hours** Code Number Stamp 130 Identify as per dwg & Stock Location: 0.00 *130* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140*

0.00

Memo

QC

Quality Control

13-2-25

| | | | | | | | | | | DQA: | Date | e: _ | |
|-----------------|------------|----------|------------|----------|--|----------|---------|--|---|---------------|--|--------|---------------------------|
| NCR: Y | es / No | | | | WORK ORDER NON-C | O | NFORI | MANCE / UPDATE | | QA Closed: | Date | ٠. | |
| | <u>.</u> . | | | | DISPOSITION | | | AGAINST I | | PARTMENT/ | | | |
| Work Orde | er: | | | | | , | | | | 1 | | \neg | |
| Part N NCR N | | | | | Rework Scrap Use-as-is Work Order Update | | Thern | Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite | | l | Water Jet d. Eng. Coor. e/Packaging Supplier | | Engineering Quality Other |
| | | | | | | _ | | | _ | , | | | |
| Root | | | | Descri | iption of work order update | | nitial | Action | İ | Sign & | | | |
| Cause | Date | Step | Qty | 4 | or Non-conformance | Ch | ief Eng | Description | | Date | Verification | _ | QC Inspector |
| Doc/Data | | | | | | | | | İ | | | | |
| Equip/Tooling | | ļ | | | | | | | İ | | | | |
| Operator | | | | | | | | | | | | | |
| Material | | ļ | | | • | | | | | | | Ì | |
| Setup | | İ | | | | | | | | | | | |
| Other | | | | | | | | | | | | | |
| Process | | | . : | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | Ш | | | | | | | | | | | | |
| Unapproved | | <u> </u> | | | | | | | | | | | |
| | | | | | | AUL | T CATE | GORY | | | | | |
| Landi | ng Gear | | | _ | General | _ | 1 | r | | 1 | г | _ | |
| | Bending | | | <u> </u> | Bend | _ | Grain | | — | Ovalized | - | | Pressure/Forced |
| | Centre N | ot Conce | ntric to (| o/s | BOM/Route | <u> </u> | Hardwa | ļ. | | Over/Under | | _ | Temperature/Cure |
| · | Cracks | | | <u> </u> | Broken/Damaged | \vdash | 4 ' | ion Incomplete | | Part Incorred | <u>-</u> | — | Weld |
| | Crushed/ | 'Crimped | | | Burrs | | 4 | ions Incomplete/Unclear | | Part Lost/Mi | ssing | | Wrong Stock Pulled |
| | Cuffs | | | <u></u> | Contamination | <u></u> | Mainte | · · · · · · · · · · · · · · · · · · · | | Part Moved | | | |
| | Heat Trea | at | | 1 | Countersink | 1 | Mislabe | eled | i | Positioned V | Vrong | | |

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes Drawing

Finish Folio

Friday, February 15, 2013 2:22:54 PM

Work Order ID:

97346

Parent Item:

D3876-1

Parent Item Name:

Protector - RH Fwd Wall

Replacement

Start Date: 2/16/2013

Required Date: 2/20/2013

Start Qty: 6.00

Required Qty: 6.00

Comments:

Item Name

Item ID

IPP Rev:A 09-01-14 new issue DD verifyed by:EC Bin

| Qty on | Qty per Kit | Total | Qty | Date | Status |
|--------|-------------|-------|-----|------|--------|

MLEXS.125-F60029-04

Component Item ID/

Item

Location

Last

Measure Hand

Unit of

sf

Qty

Issued Issued .

GE PLASTICS LEXAN SHEET

Purchased

Mfg/

Purch

No

Primary

Location

Seq ID 100

Route

0.0000

3.607

Page 1

124654

124654

| | | | | | | | | | | | | DQA: | Dat | e: _ | |
|---------------|----------|----------------|------------|----------|--|--|------------------|--------------|-------------------|-----------|---------|------------------|---------------|--------------|--------------------|
| NCR: \ | es/ | / No | | | | WORK ORDER NON-C | 100 | VFORM | ANCE / UPE | DATE | | _ | | | |
| | | | | | | | | | | | Q | A Closed: | Dat | e: | |
| Work Orde | ır. | | | | | DISPOSITION AGAINST I | | AGAINST DE | PΑ | ARTMENT/ | PROCESS | | | | |
| Work Orac | • | | | | | Rework | 1 | | Skid-tube | Crosstube | 7 | | Water Jet | \neg | Engineering |
| Part N | ۱o. | | | | | Scrap | | · | Machining | Small Fab | 1 | Proc | l. Eng. Coor. | | Quality |
| | | | | | ······································ | Use-as-is | | Therm | noforming | Finishing |] | Rec/Stor | e/Packaging | | Other |
| NCR N | ۱o. | | | | | Work Order Update | | | Large Fab | Composite | _ | | Supplier | | |
| D | _ | | 1 | | Danasi | ntian of work and ar undata | | nitial | Act | ion | T | Sign & | | _ | |
| Root | | Data | Ctan | O+ | | ption of work order update or Non-conformance | | nief Eng | | ription | | Date | Verification | | QC Inspector |
| Cause | | Date | Step | Qty | | or Non-conformance | Cn | ner Eng | Descr | триоп | ╁ | Date | vermuation | ` | QC IIIspector |
| Doc/Data | - | | <u> </u> | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | - | | | | | | | | | | | | | l | |
| Material | - | | | | | | | , | | | | | | | |
| Setup | - | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | |
| Process | \dashv | | | | | | | | | | | | | Ì | |
| Supplier | \dashv | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | <u> </u> | <u> </u> | <u> </u> | F | <u> 1</u> Диі | T CATE | GORY | | | | | | |
| Landi | ng (| ear | | | | General | | | | | | | | | |
| | | Bending | | | | Bend | | Grain | | | | valized | | | Pressure/Forced |
| | | | BOM/Route | Г | Hardwa | re | | | ver/Under | tolerance | | Temperature/Cure | | | |
| Cracks | | Broken/Damaged | | Inspecti | on Incomplete | | Īρ | art Incorred | :t | | Weld | | | | |
| | - | Crushed/ | Crimped. | | | Burrs | | 4 ' | ions Incomplete/U | Jnclear | P | art Lost/Mi | ssing | | Wrong Stock Pulled |
| | | Cuffs | • | | | Contamination | | Mainte | • | | P | art Moved | ı | | • |
| | | Heat Trea | it | | | Countersink | | Mislabe | lec | | ΠP | ositioned V | Vrong | | |
| | | Inspection | n Strip in | Tube | | Cut Too Short | | Misread | i | | P | ower Loss/ | Surge | | Other |

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish

Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| DART AEROSPACE LTD | Work Order: | 97346 |
|--------------------------------------|--------------|-------------|
| Description: Protector – RH Fwd Wall | Part Number: | D3876-1 |
| Inspection Dwg: D3876 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Х | First Article | Prototype | , |
|---|---------------|-----------|---|
|---|---------------|-----------|---|

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|-----------|---------------------|---------------------------------------|--------|-------------------------|---------------------------------------|
| 21.09 | +/-0.030 | 21.09" | L | | T | Jkm06 |
| 20.23 | +/-0.030 | 20.23' | _ | | T | |
| 24.63 | +/-0.030 | 24.63 | u | | ٢ | |
| 0.86 | +/-0.030 | 0.96" | ل | | V | Jhmo: |
| 0.125 | +/-0.010 | p.126" | U | | U | |
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| | 7 | | 240 | r | | · · · · · · · · · · · · · · · · · · · |

| Measured by: | Jm | Audited by: | Prototype Approval: | N/A |
|--------------|---------|----------------|---------------------|-----|
| Date: | 13-2-21 | Date: 13.25.21 | Date: | N/A |

| Rev | Date | Change | Revised b | y Approved |
|-----|----------|-----------|-----------|------------|
| Α | 09.06.22 | New Issue | KJ 🚓 | - 4 |
| | | | 71 | |

